

Work Order ID 77186

November-28-11 9:05:20 AM

77186

Page 1

Item ID: K10003

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/12/2011

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: *M.L.J*

Date: *11/11/28*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 007

n 12 01 05 (4)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 11-12-21

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

n 12 01 05 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77186

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77186

Page 2

Item ID: K10003 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, D205-634-011
 Start Date: 28/11/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging	<u>Rev I</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SP 12-01-05

CK 12/01/06

M.L.J 12/01/05
 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 1

Work Order ID: 77186

77186

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: 1 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP: J 06-07-25 As per DSI 9344 JLM
 IPP: K 06.11.17 Per K10003 Rev C KJ
 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ
 IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev:O
 11.03.11 per dsi9536 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-51A
 AN4-51A
 Bolt

Purchased

No

110

Each

124.0000

8

40

**

x M 119798 SP.

Location

Loc Qty

Loc Code

ST361

124

118706

50

118983

24

119127

50

AN4-6A
 AN4-6A
 Bolt

Purchased

No

110

Each

4,574.000

16

80

**

80x SP.

Location

Loc Qty

Loc Code

ST516

4574

119017

4574

AN4C46A
 AN4C46A
 BOLT

Purchased

No

110

Each

26.0000

4

20

**

M 119849 SP
 11-12-21

Location

Loc Qty

Loc Code

ST086

1

107287

1

ST360

25

119745

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 77186

77186

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

AN6-I2A

Purchased

No

110

Each

71.0000

8

40

AN6-12A

Bolt

**

m119934 SP.

Location

Loc Qty

Loc Code

ST341

71

119127

21

119749

50

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

32

160

AN960.ID416

Washer

**

m119075

AN960JD616

NAS1149D0663J

Purchased

No

110

Each

0.0000

8

40

AN960.ID616

Washer

**

m119075 SP.

D2570

Manufactured

No

110

Each

82.0000

24

120

D2570

Bushing

**

B77421 SP.

Location

Loc Qty

Loc Code

ST017

82

66933

1

67759

14

72122

1

72960

41

74868

25

D2571

Manufactured

No

110

Each

6.0000

1

5

D2571

Saddle, Fwd Out 205

**

B760438 SP.

11-12-21.

Location

Loc Qty

Loc Code

ST

6

11644

0

76375

6

November-28-11 9:05:24 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 77186

77186

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

D2572

Manufactured No

110 Each

3.0000

1

5

D2572

Saddle, Fwd In 205

**

Location

Loc Qty

Loc Code

ST433

2

71107

2

ST444

1

76376

1

D2573

Manufactured No

110 Each

2.0000

1

5

D2573

Saddle, Aft Out 205

**

Location

Loc Qty

Loc Code

ST

1

76377

1

ST423

-11

73682

1

ST434

12

D2574

Manufactured No

110 Each

2.0000

1

5

D2574

Saddle, Aft In 205

**

Location

Loc Qty

Loc Code

ST425

1

73684

1

ST434

1

76378

1

D2747

Manufactured No

110 Each

66.0000

4

20

D2747

Set Screw

**

Location

Loc Qty

Loc Code

ST021

66

73495

66

November-28-11 9:05:24 AM

Shop Packet Print

Page 3

B76442 1x SP
B77246 4x SP
12/12

B76451 2x SP
3x B77287 SP
12/12

B76439 2x SP
B77286 3x SP
12/12

SP
B77484 2x
~~20x~~ 10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 77186

77186

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

D2876
D2876
Saddle Spacer

Manufactured No

110 Each 27.0000 2 10

**

Location

Loc Qty

Loc Code

ST025

27

73308

27

Manufactured No

110 Each 57.0000 2 10

**

Location

Loc Qty

Loc Code

ST025

57

73309

57

Manufactured No

110 Each 5.0000 1 5

**

D3405-041
D3405-041
Lug Assembly

Location

Loc Qty

Loc Code

ST474

3

62227

2

68970

1

ST748

2

74549

2

Manufactured No

110 Each 6.0000 1 5

**

D3405-043
D3405-043
Lug Assembly

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST478

4

68343

1

74550

3

SP
B 76949 7x.

3x

SP.

10x
B 76218 SP.
3x 77000 SP.
12/1/5

B 76221
11-12-21 SP.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 77186

77186

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

D3407-041

Manufactured No

110 Each

10.0000

1 5

D3407-041

Tow Ring

**

B76223 SP

Location

Loc Qty

Loc Code

ST463

10

75029

10

D3417-5

Manufactured No

110 Each

45.0000

2 10

D3417-5

Washer

**

SP

Location

Loc Qty

Loc Code

ST053

45

73326

5

75044

40

D3456-1

Manufactured No

110 Each

61.0000

1 5

D3456-1

Washer

**

SP

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

54

66848

3

71165

2

73493

49

D3533-1

Manufactured No

110 Each

54.0000

2 10

D3533-1

Set Screw

**

SP 11-12-21

Location

Loc Qty

Loc Code

ST065

54

73310

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 77186

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

77186

K10003

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

110

Each

10,709.00

24

120

MS21042I 4

Nut

**

Location

Loc Qty

Loc Code

ST300

546

117441

51

117601

362

118451

133

ST516

5163

119017

5163

ST518

5000

119075

5000

120x

MS21043-4

Purchased

No

110

Each

1,453.000

5

25

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1413

117793

5

118686

470

119309

438

119546

500

25x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D205-634

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5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				NAS1149D0668J	WASHER (AN960JD616)
29	16	16				AN4-6A	BOLT
30	32	32				NAS1149D0463J	WASHER (AN960JD416)
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C46A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

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Revision: G

Date: 11.06.24